

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020600**Date Inspected:** 21-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Huang Min and Lil Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** BAY 6 and 8 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A.DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 8

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on Bike Path component(s), identified as BK004A1-059 weld number(s) 043. Welder is identified as welder no. 066439. The welding variables recorded by ZPMC QC identified as Mr. Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U4C-F.

FCAW welding of complete joint penetration weld joint(s) located on Bike Path component(s), identified as BK004A6-064 weld number(s) 044. Welder is identified as welder no. 066439. The welding variables recorded by ZPMC QC identified as Mr. Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U4C-F.

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OBG BAY 8

During random in process inspection of Bike Path member, identified as BK004A1-057 weld number(s) 044 this QA observed carbon arc gouging of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected 36 areas within weld no. 044. This QA measured depth and length of excavation of the affected area and informed ZPMC Quality Control (QC) identified as Mr. Liu Fa Wen that 10-excavations appeared to exceed 65-percent of base metal thickness. Mr. Liu Fa Wen informed this QA that welding of the excavations would be corrected in a manner compliant with the contract documents.

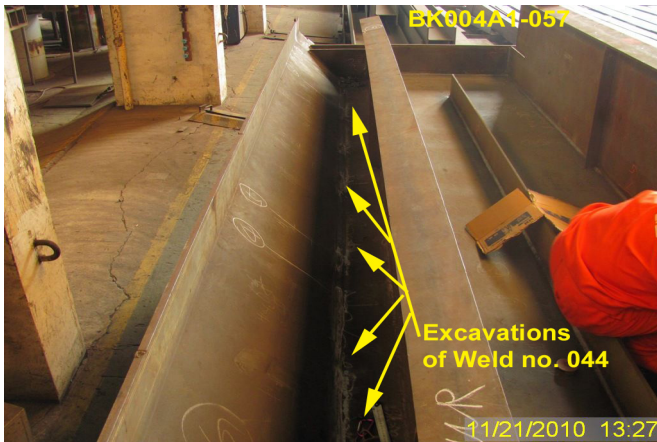
OBG BAY 6

HEAT STRAIGHTENING

This QA Inspector observed the following work in progress:

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as Lift 14 Sub-Assembly DP3168B-001, weld joint(s) 098, 099, 103, 104, 106, 107, 109, 110, 112, 113, 115, 116, 123, 139, 137, 138, 139, and 140. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Li Jia was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR1 (B)-433 dated 11-10-2010.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As mentioned above between QA and QC concerning this project

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Devy 150-002-6784, who represents the Office of Structural Materials for your

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project.

Inspected By: DeArmond,Robert

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer